



# भारतीय प्रौद्योगिकी संस्थान (भारतीय खनि विद्यापीठ), धनबाद

धनबाद, झारखण्ड, भारत, पिन-826004

(मानव संसाधन विकास मंत्रालय, भारत सरकार के अधीन राष्ट्रीय महत्व का एक संस्थान)

INDIAN INSTITUTE OF TECHNOLOGY (INDIAN SCHOOL OF MINES), DHANBAD

DHANBAD, JHARKHAND, INDIA, PIN-826004

(An Institute of National Importance under Ministry of H.R.D., Govt. of India)

STORES & PURCHASE SECTION Phone:(0326) 2235678 || Email : purchase@iitism.ac.in || Website : www.iitism.ac.in

NIT No.: Mech-PRJ-098-18-19

Date: July 5, 2018

## NOTICE INVITING TENDER

**Subject:** NIT No. Mech-PRJ-098-18-19 for Supply and Installation of System for Micro-electrochemical spark machining

Indian Institute of Technology (Indian School of Mines), Dhanbad invites tenders/ quotations for supply and installation of System for Micro-electrochemical in our Mech. Engg. Department. **Particulars of tender cost, earnest money deposit and date and time of submission and opening of tenders are as under:**

S No	Items	Particulars
1.	Tender cost	Rs. 2,000.00
2.	Earnest money deposit	Rs. 44,000.00
3.	Last date and time for submission of tenders	<b>01.08.2018 at 1:00 P.M.</b>
4.	Date and time of opening of tenders	<b>01.08.2018 at 3:00 P.M.</b>

Tender document containing following document is available in our website [www.iitism.ac.in/tender](http://www.iitism.ac.in/tender) page, which may kindly be referred.

1. Technical specifications as per Annexure-I
2. General terms & condition as per Annexure-II
3. Acceptance of terms & conditions as per Annexure-III
4. Financial bid format-IV
5. Compliance Statement as per Annexure -V

Encl : As above

Deputy Registrar



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**Annexure-I**

## **Technical specifications and techno-commercial statements:**

### **System for micro electrochemical spark machining**

This proposed machine is for Electrochemical spark machining (ECSM/ECDM) of electrically conductive and non-conductive materials. Where in buyer would conduct various experiments & tests. The machine with specifications given below to be fabricated. The said machine should be kept in controlled temperature room/ casing to get required respectabilities. Machine will have approximately 200 x 200x 200 mm travel in all the axes called as X, Y & Z axes. In ECDM process fume is expected while machining hence the fume extractor to be fitted to the machining chamber. This Electro-Mechanical setup will essentially have mechanical & control units. All axes movements should be very smooth & should not have any vibration /jerk/ cogging. Suitable enclosure to be provided for control parts. The axes motion to be controlled from the CNC controller and all synchronization to be performed. The CNC Package/ motion controller should be from Siemens only. The aim of said ECDM machine is to achieve desired movements at desired Speed to machine metallic & nonmetallic parts by electrochemical sparks. Figure 1 represents approximate arrangement of the XYZ stages and Figure 2 represents the approximate outer casing of the machine. These figures are not given according to the dimensions.

The broad specifications and specification of individual components of the proposed machine are as below:

General Specifications	Size/part name/conditions
Max Travel of the axes (X x Y x Z)	200 mm x 200mm x 200mm
Motor for stages	Digital AC servo motors with feedback systems
Machining Tank Size	Approximately 300mm x 300mm x 100mm (height)
Component Size	Less than or equal 100mm x 100mm
Machining Tank Material	Stainless steel: Anti-Corrosion Material, one side transparent for easy visualization of the machining process.
Resolution of all the axes	1 micron or less
Positional accuracy	± 5microns
Table Material	Granite (Will be used for anti- vibration)
Controller	Siemens 828/840 D SL CNC
Spindle mounting	On Z axis
Slide Construction (X,Y,Z axes)	Ball lead screw of C3 or better
Spindle Diameter :	Less than 100mm (preferably)
Spindle motor	AC servo motor
Spindle motor	1000RPM maximum
Spindle Collet System	HSK system (to be electrically isolated from the machine tool structure)
Collet holding range	0 to 2 mm ( the upper limit may be varied but not less than 1mm)



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	Multiple collets may be provided to manage the range of holding.
Work Holding Device	Proper work holding devices like vice, clamps for holding the job on the table to be provided, Preferably of stainless steel/Teflon. Ultrasonic vibration to the job to be provided as separate attachment. Source of Vibration will be inside the tank.
Programming language	Standard ISO
Pulse power generator	To be provided and will have provision to vary input machining parameters like Pulse width, frequency, Duty factor, Machining Voltage. The parameters are to be controlled separately
Tool monitoring device	Suitable online/ off line system for tool diameter monitoring to be provided.
Filter	Proper filtering unit with 5µm particle filter to be provided to filter the debris from the used electrolyte
Electrolyte	Suitable Chemical pump to be provided to pump the electrolyte specified by buyer
Pump	Suitable Chemical pump to be provided to pump the electrolyte into the machining tank with variable discharge rate ( 0.25 liter/minute to 2 l/minute or suitable range)
Electrolytic Tank	a) 20 lit capacity b) Anti-corrosion material
Fume Exhauster	Suitable one for chemical fume to be provided
Power Supply	3 phase AC 400V±10%, 50HZ±5%, 3Phase. For CNC controller and stages.

## Specification of individual components

### XYZ CNC stages with controller and base plate.

#### XYZ CNC stages

Travel: X and Y: 200mm; Z axis: 200mm; Resolution: 1µm in each axis; position accuracy: 5 µm in each axis. Straightness uncertainty over the total travel range:5µm for all axes; Minimum travel Speed:100 microns /min in all axes; Motors: Digital AC servo drives for all three axes; Vertical load capacity (load perpendicular to table surface): 30 kg or more ( less than 50 Kg) ; Horizontal load capacity:15kg or more; Recirculating ball screws in all the axes (THK/ Thomson to meet this precision); X-Y will be mounted together on the machine base plate and Z will be mounted on the vertical column of the machine, as provided in the figure 1.The base plate of material SS, thickness 10mm with suitable size and a column with height adjustment facility to be provided.An maximum angular deviation of 0.05 degree and maximum linear deviation of 5 micron is permitted for XYZ stages mounting.

#### Controller specification:

1) Siemens CNC 828D/ 840 D SL controller. Position loop can be closed





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	<p>using external scale from Fagor/ SCHNEEBERGER in built scale in LM Guide with 1 Micron resolution. Spindle run out error limit: +/- 5 Micron)</p> <p>2) Voltage triggering option for all the stages: 2 to 5V for controlling the stage motion in all the axes.</p> <p>During the machining operation, the electrical sparks will be produced between the two electrodes when they are at close vicinity. After the sparks, the material from both the electrodes is removed so the gap increases. To get continuous sparks the gap has to be maintained at a threshold level and to achieve this, one of electrodes mounted on the CNC stages has to move closer. The triggering voltage/gap voltage is responsible for this movement of the stages in the desired direction at desired speed.</p> <p>3) Controlled motion of all the three axes with respect to the triggering voltage (gap voltage).</p> <p>4) Emergency stop button (hardware)</p> <p>5) Programming options:</p> <ul style="list-style-type: none"> <li>• Machine start, stop, home etc.</li> <li>• Home position for X-Y-Z axes should will close to one end of the stroke</li> <li>• Machine stop when stages touch the limit switches or the end of program.</li> <li>• Liner interpolation and circular interpolation.</li> <li>• Other options required for the machining operations such as electrolyte pump on/off, pulsed power supply on/off etc.</li> <li>• Control of digital AC spindle motor speed (10 to 1000rpm). Spindle on/ off, feed rate, dwell time.</li> <li>• All normal CNC functions and front end panel need to be designed by the vendor will be suitable for the present machine.</li> </ul> <p>6) All the required logic is to be developed by the vendor to run the machine smoothly with minimum features described above, which includes the design of front panel inbuilt control programs etc.</p> <p>7) All programs of vertical CNC milling to be incorporated in addition, the inter electrode gap control mechanism/ device /circuit to be provided.</p>
<p><b>Spindle assembly</b></p>	<p><b>Motor:</b> Digital AC servo motors, <b>power:</b> 500 Watt</p> <p><b>Operational rotational speed range:</b> 10rpm to 1000rpm</p> <p><b>Chuck assembly and tool holding system:</b></p> <p>HSK chuck with collet sets to hold the cylindrical tools of diameter range up to 02mm (multiple collet to be provided to manage the range). Run out error for the tool after holding in the spindle : &lt;±5 micron consistently, suitable HSK make wrench and nuts to be provided by which the tools within the above diameter range may be fitted in the chuck.</p>



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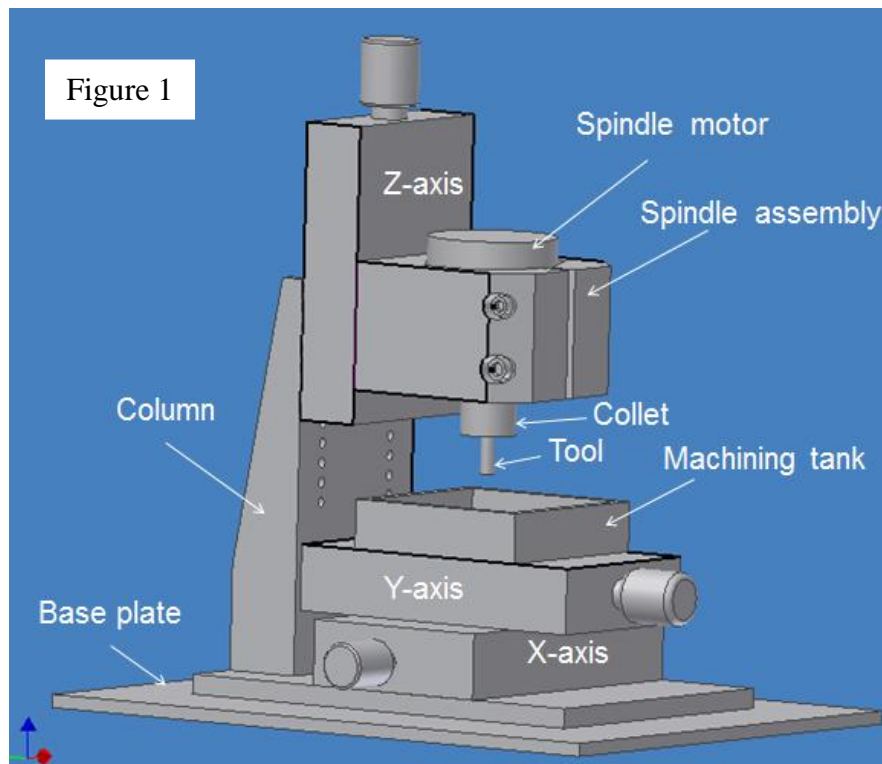
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	<b>Power transmission from motor to chuck system:</b> direct or timer belt The collet system should be electrically isolated from the spindle assembly.
<b>DC pulse Power supply</b>	Duty factor variation range: up to 80%, voltage variation range: up to 150VDC, Frequency: up to 10kHz. Minimum pulse on time less than or $\approx 0.5$ micro second. The machining circuit should be electrically insulated from the body of the machine. The control and setting of above parameters must be done from the controller and also can be performed independently from the power supply. The power supply should include the LED/LCD display to show all the parameters. It should have auxiliary port or wires to capture and analyze the signal in the oscilloscope.
<b>Inter electrode gap control</b>	The machining voltage or current during the machining process to be acquired with a level of accuracy of 0.01mA and converted to a low voltage of up to 5V which can be used as the trigger voltage and with reference to that voltage the spark machining/gap control will be carried out in the electrolyte medium.





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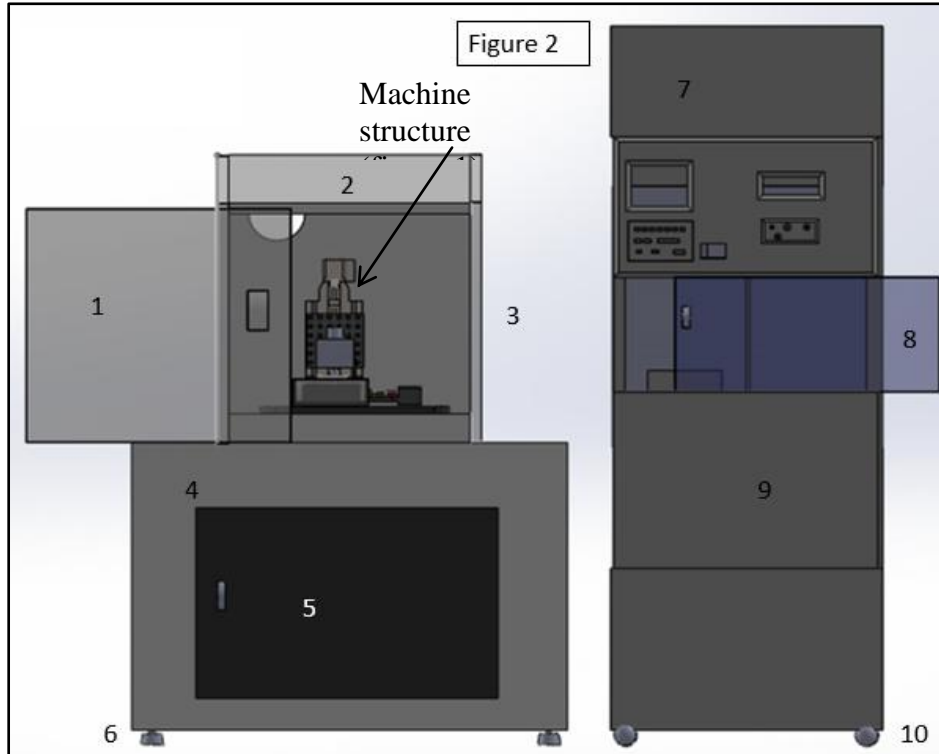
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## Specification of the casing of the machine:

Sl. No	Material		Thickness (mm)
Machining Chamber			
1	Door	Acrylic Transparent Sheet	10
2	Frame and cover	Stainless Steel flat/sheet (powder coated)	05 and 02
3	Side wall	Acrylic Transparent Sheet	08
Machining Chamber Bed			
4	Table top	Stainless Steel sheet (powder coated)	05
5	Door		03
6	Leveling Screw (4nos)	SS	M15
Control Unit			



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7	Frame and cover	Stainless Steel flat/sheet (powder coated)	05 and 02
8	Door	Acrylic Transparent Sheet	08
9	Door (Space for power Supply)	Stainless Steel flat/sheet (powder coated)	03
10	Wheel (4nos)	Suitable material	----

## Techno-commercial terms and conditions:

- 1) Compliance statement must be provided and any deviation must be clearly mentioned.
- 2) Specifications and make model of all the components must be mentioned and the relevant literature must be provided as supporting documents.
- 3) Replacement warranty for two years must be included in the technical and price bid.
- 4) Before delivery of the machine the vendor must demonstrate the working of the said machine, geometrical accuracy. After satisfaction of the review committee, the vendor may despatch the machine to the installation site.
- 5) The installation site will be declared by IIT(ISM) after the satisfactory report on working of the machine by the buyer.
- 6) The vendor must provide the declaration on legal paper not to sell the similar machine (based on the same principle) without prior permission of IIT(ISM).
- 7) The price must include base price, all taxes, installation and training and onsite warranty coverage for two years.
- 8) If a vendor does not supply all the documents at the time of submission of tender, her documents will not be considered for further processing.





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## Annexure-II

### GENERAL TERMS & CONDITIONS

#### NIT No. Mech-PRJ-098-18-19

Sealed tenders under **two-bid system** are invited from manufacturers/ their authorized dealers/agents for supply and installation in IIT (ISM) Dhanbad of items specified in *Annexure-I*.

- Offer should be submitted under **TWO BID** system in two separate sealed covers i.e. “**Techno-commercial bid**” and “**Price bid**”.
- In a tender, either the Indian agent on behalf of the principle/OEM itself can bid but both cannot bid simultaneously for the same item/product in the same tender.*
  - If an agent submit bid on behalf of the principle/OEM, the same agent shall not submit a bid on behalf of another principle/OEM in the same tender for the same item/product. There must be authorization letter for this tender reference issued by principle/ OEM in firm of the agent.*
- Techno-commercial Bid:** should contain the following documents/information:
  - Tender Cost:** Cost of the tender document is to be paid by way of an A/C payee demand draft and drawn in favor of Registrar, IIT (ISM) Dhanbad and payable at any other Bank/Branch located in Dhanbad. Tender cost is **non-refundable and non-transferable**. Alternatively, intending tenderers may download the complete set of tender document from IIT (ISM) website ([www.iitism.ac.in](http://www.iitism.ac.in)) and submit the same duly signed on all pages by the tenderers along with demand draft for tender cost
  - Earnest Money Deposit (EMD):** Should be submitted in form of A/C payee demand draft drawn in favor of Registrar, IIT (ISM), Dhanbad and payable at any other Bank/ Branch located in Dhanbad. It can also be submitted in the form of bank guarantee issued by a Nationalized Bank in India in the format given in Annexure-IV.
  - Tenders without payment of tender cost and EMD may not be considered unless the tenderer is exempt from such payment under Govt. Rules/Regulations as amended from time to time and claims such exemption along with relevant and valid supporting documents.
  - All relevant technical specifications/details of offered items, drawings, printed technical leaflets, and commercial details which are necessary to ensure that offer is complete in all respects.
  - A ‘Compliance Statement’ along with a certificate and duly signed that the tenderer satisfies the technical requirements given in **Annexure-I**. The said statement should be in a tabular form with the columns: sl. no., (2) technical requirement as per NIT; (3) what is offered by the tenderer; and (4) status of compliance: Complied/Not complied).*
  - IIT (ISM) does not bind itself to offer any explanation to those bidders whose Technical Bids have not been found acceptable by the Evaluation Committee of the Institute.
- The packing, forwarding, freight and transit insurance charges, if any must be included in the price and should not be claimed separately. Duties & taxes, if applicable, are to be shown separately clarifying whether those are extra or included in the price. **Price bids of only technically short-listed tenderers shall be opened.**
- Educational discount, if any, should be clearly mentioned.**
- IIT (ISM) is entitled for custom, excise Duty Exemption under Govt of India notifications and is registered with DSIR, Govt of India for this purpose. This may be taken into consideration while quoting minimum possible rate. IIT (ISM) has not agreed any high sea sales Purchase. IIT (ISM) will provide only custom duty exemption certificate for availing concessional custom duty. IIT (ISM) will not pay any extra custom duty other than duty exemption certificate.
- IIT (ISM) does not issue form ‘C’ or ‘D’ for concessional Sales tax/VAT. Hence, full rate of sales tax as applicable to educational institutions against the form of certificate (enclosed as Annexure V) should be indicated.
- Warranty:** Minimum 36 months from the date of installation and commissioning at the site.





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9. **Validity:** Offer must be valid for a period of **180 days** from the date of opening of tender.
10. Price should be quoted on FOR, Dhanbad basis only.
11. Your full address for correspondence and name address of the beneficiary's banker should be clearly indicated in the offer.
12. One set of technical literature/catalogue with the detail specification of the material under purchase should be furnished with the offer.
13. Earliest/expected delivery period should be clearly indicated.
14. The offer should reach at the earliest in a sealed envelope superscribed 'Enquiry Reference Number and due date' address to  
**Deputy Registrar (P&S),  
Indian Institute of Technology (Indian School of Mines),  
Dhanbad-826004, Jharkhand, India.**
15. **Performance Bank Guarantee (PBG):** Successful bidder has to submit a bank guarantee issued by a Nationalized Bank in India towards PBG within two weeks of placement of purchase order for an amount equal to 10% of order value of purchase order and valid till the period beyond two months of completion of warranty period should be submitted in favour of **REGISTRAR, IIT (ISM) DHANBAD.**
16. **Delivery Period and Liquidated Damage:** The ordered materials/work complete in all respects are required to be delivered and installed within the period stipulated in the purchase order failing which liquidated damages of 1% per week for the delayed period subject to maximum of 5% of the total basic value of the order shall be deducted from the invoice of the supplier.
17. **Inspection:** Inspection shall be carried out at IIT (ISM), Dhanbad after arrival of the materials and decision of the Institute in this regard shall be final.
18. **Rejection and Replacement:** Rejection, if any, shall be notified to the supplier within 30 days of receipt and inspection of the material/workmanship. Rejected materials/work is to be removed by the supplier at his own risk and cost from IIT (ISM). Campus within 14 days of intimation of rejection. Defective Supplies are required to be replaced within 15 days of the removal of the rejected materials/work.
19. **Risk Purchase:** IIT (ISM) shall be at liberty to realize from the supplier the differential amount, if any, which it shall have to incur on purchase of the material/work at higher price(s) from elsewhere in the market, if the supplier, due to their fault, fails to supply the ordered quality and quantity of the material/work within the stipulated time.
20. **Conditional offer will not be accepted.**
21. Any kind of advance or part payment will not be released.
22. Payment will be made within 30 days after satisfactory supply, inspection, installation/commissioning & acceptance and on submission of pre-receipted tax invoice, delivery challan, warranty certificate and installation report in triplicate and performance bank guarantee followed by its verification. The invoice should be duly certified by the Head of Dept to which supply is made or any other IIT (ISM) official authorized for this purpose.
29. **Last date** for receipt of tenders and date & time for opening of the same is given above. In the event last date is a holiday/declared as a holiday, next working date will be the last date for submission/ opening of tender. IIT(ISM) may extend/ revise these date & time as per its rules.
30. (i) Tender should be submitted in a sealed cover/envelope and must be superscribed as:  
"Tender No. \_\_\_\_\_ (NIT no. should be mentioned for \_\_\_\_\_ (tendered item should be mentioned) due on \_\_\_\_\_ (tender opening date should be mentioned) at \_\_\_\_\_ (tender opening time should be mentioned).  
(ii) All tender shall be received upto to the time and date as stated in the tender notice, after which no tender shall be accepted in any circumstances.  
(iii) All tender must be send by Registered Post/Speed Post/Courier along with Courier receipt, during



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IIT (ISM) working days, working hours only (i.e. Monday to Friday). Please note that no hand delivery of tender will be received at any circumstances.

31. IIT (ISM) reserves the right to accept or reject any or all the bids in part or in full without assigning any reason and does not bind himself to accept the lowest bid. The Institute at its discretion may change the quantity/quality/parameters/upgrade the criteria/drop any item(s) or part thereof at any time before or after placing the order. IIT(ISM) reserves the right to change/ cancel the purchase order at any stage without assigning any reason/ notice thereof.
32. In case of any dispute, the decision of IIT (ISM) shall be final and binding on the bidders/tenderers.



# भारतीय प्रौद्योगिकी संस्थान (भारतीय खनि विद्यापीठ), धनबाद

धनबाद, झारखण्ड, भारत, पिन-826004

(मानव संसाधन विकास मंत्रालय, भारत सरकार के अधीन राष्ट्रीय महत्व का एक संस्थान)

**INDIAN INSTITUTE OF TECHNOLOGY (INDIAN SCHOOL OF MINES), DHANBAD**

**DHANBAD, JHARKHAND, INDIA, PIN-826004**

**(An Institute of National Importance under Ministry of H.R.D., Govt. of India)**

**STORES & PURCHASE SECTION** Phone:(0326) 2235678 || Email : [purchase@iitism.ac.in](mailto:purchase@iitism.ac.in) || Website : [www.iitism.ac.in](http://www.iitism.ac.in)

NIT No.: Mech-PRJ-098-18-19

Date: July 5, 2018

**Annexure-III**

## **ABOVE TERMS AND CONDITIONS OF THE NIT ARE ACCEPTED**

1	Name and address of the tenderer	
2	Telecom nos. of the tenderer i.e. phone & email id.	
3	Signature, name & designation of the person signing on behalf of the tenderer & his/her office seal	
4.	Name & designation of the contact person & his phone/mobile no.	





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NIT No.: Mech-PRJ-098-18-19

Date: July 5, 2018

## Annexure-IV

### Format for Financial Bid

NIT No.: Mech-PRJ-098-18-19

Date:

Bidders Ref: No.

Date:

GSTIN No.:

**Subject: Supply & Installation of System for Micro-electrochemical**

Sl. No.	Full Description of Items with (HSN Code/SAC Code)	Qty.	Rate	Amount
			Packing & Forwarding (if any)	
			<b>Total</b>	
			GST	
			Freight (if any)	
			Installation (if any)	
Amount should be in figure as well as word (FOR IIT(ISM), Dhanbad basis)			<b>Grand Total</b>	

#### **Note:**

- 1) All the details must be provided as per prescribed format only
- 2) Prices quoted by the bidders should include GST, HSN Code, SAC Code, duties, livies, transportation cost and insurance costs etc. if any
- 3) All the rates must be quoted in Indian Rupees.



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Annexure-V

## Compliance Statement

Sl. No	Technical requirement as per NIT	What is offered by the tenderer	Status of Compliance Complied/Not Complied
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